



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBE350A93-3500-00
Job Sheet 193184



Part No: RBE350A93-3500-00

Job Qty: 16 pcs

Part Name: Bearing Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD *slh*

Description:

Note: DWG RBE350A93-3500-00 Rev 3A IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	16 pcs	5/6/19	5/6/19	0.00	4.00	Small Fab - 1		<i>MLL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	16 pcs	5/6/19	5/6/19	0.00	0.00	QC 5 - 10		<i>DAS</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	16 pcs	5/6/19	5/6/19	0.00	0.00	Packaging 3 - 1 - B4B		<i>DAS</i> 40 JUN 04 2019 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S186607



Part: RBE350A93 - 3500 - 00

Job No: 193184

Serial No/Batch: S186607

Revision: 3A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Date: 06/03/19

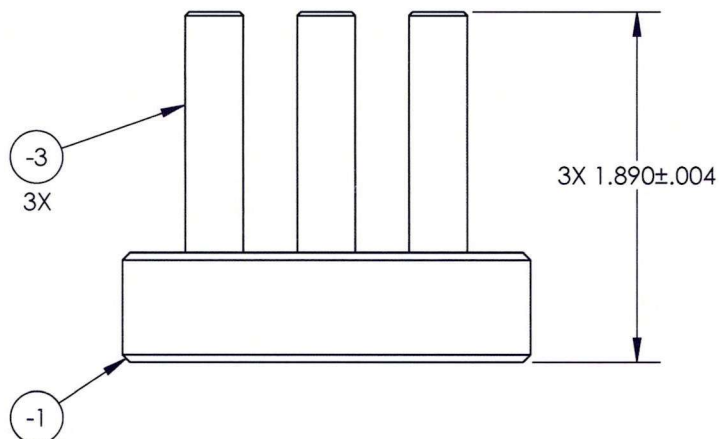
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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	16 pcs	5/6/19	0.00 0.00	QC 21 - FG - 21	Dara M
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21
Part Op 110 - (Small Fab) -Assemble as per DWG. Press fit dowels					
Descriptions: 120 - QC5- Inspect part completeness to step on W/O)					
130 - (Identify as per dwg & Stock Location:_____)					
140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
91585A208	Dowel Pin M8 x 40mm	48 Ea (3 ea)	110-Small Fab - 1	20 5176122	28 5176126
RBE350A93-3500-00-1	Body	16 pcs (1 ea)	110-Small Fab - 1	5176 998	72
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	91585A208	48	23	0	
	RBE350A93-3500-00-1	16	0	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED PIN MATERIAL FROM 1018 RND. TO 304 S.S. BAR	5/27/09	WP	
1A	-1 REMOVED REF. FROM B.C. Ø1.393 DIMENSION. ADDED (.6965) DIMENSION PER G.E.	9/15/11	RJC	RW
2	VERIFIED AND CORRECTED -1 DIMENSIONS TO MATCH THE ORIGINAL DWG. REPLACED -3 PIN WITH DOWEL PIN. CHANGED ASSEMBLED PIN HIEGHT FROM 1.306 TO 1.890±.004 PER ORIGINAL DWG.	7/24/2012	RJC	SE
3	CH'D COUNTER BORE DEPTH WAS .323 IS .275. ADDED DWG. FOR -3 TO MODIFY DOWEL PIN.	4/18/2013	CFS	RW
3A	CH'D T/N WAS RBEA93-3500-00 IS RBE350A93-3500-00. CH'D TOOL NAME WAS BEARING EXTRACTOR, HYDRAULIC PUMP IS BEARING EXTRACTOR.	11/6/2013	RJC	RW



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193184 MLC
19-04-09

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	Ø2-1/4 X 3/4	2
			-3	3	DOWEL PIN	18-8	Ø8mm X 40mm MCMaster-CARR #91585A208 (MODIFIED.)	3

RED BARN MACHINE	
TITLE BEARING EXTRACTOR	
DWG NO. RBE350A93-3500-00	REV 3A
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: CLOUGH APPROVED: D Weil HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER 350A
SCALE 1:1	DATE 7/24/2012
SHEET 1 OF 3	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					